

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014920**Date Inspected:** 19-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 8AW+8BW splice weld and temporary attachment areas. The weld designations reviewed are as follows:

8AW+8BW

1. OBW8-001, 002, 003, 004 and 005
2. OBW8B-003 and 004

This QA Inspector performed MT of area previously tested and accepted by Quality Control on OBG 5AE+ 5BE. MT was performed on temporary attachment on segment splice 5AE+5BE (bike path side). QA Inspector observed three longitudinal linear indications, measuring approximately between 9mm and 40mm in length respectively at various locations. The QA Inspector generated a TL-6028 MT report on this date.

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Weld MT verified was identified as listed below

Temporary Attachments on 8AW+8BW

1. OBW8B-001 (3 locations) counter weight side of segment.

This QA Inspector issued an incident report on the above noted MT rejections.

1. OBW8B-005 (1 location) cross beam side of segment.

This QA Inspector issued an incident report on the above noted MT rejection.

8CW

Shield Metal Arc Welding (SMAW) VT repair welding was performed various locations on the field splice edge and temporary attachment areas counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1414 procedure.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

8 East/ 8 West/ 7 East

1. Sea fasteners and cable trays are being installed at various locations inside segment.

7 West

1. Grit blasting at various locations (internal/ external) on segment.

NDT Observation

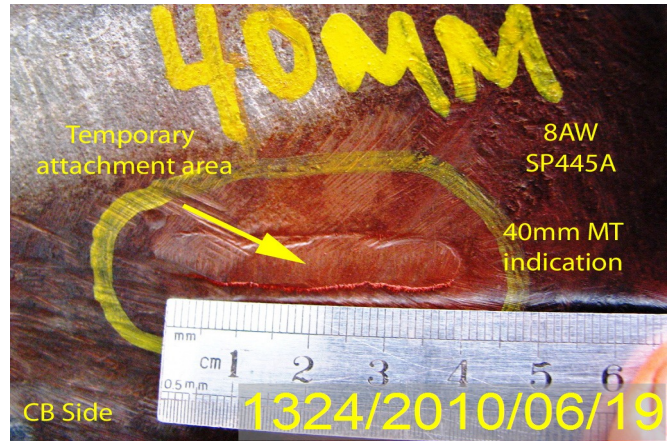
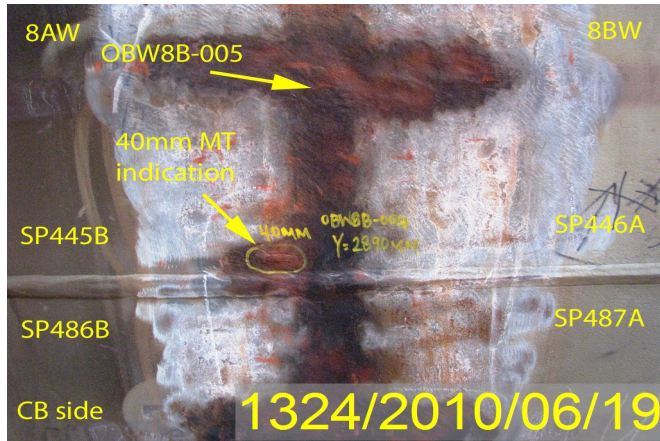
This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

1. Performed on the counter weight connection plates (OBW7N-011/012) located on the counter weight side of segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
